Work Orde Wednesday, Sept											Page 1
Revision ID:	D4091-1 Mounting Lug		10 A	Accept					Setup Star		
Start Date: Required Date: Reference:	9/14/2010 9/21/2010	Start Qty: 8.00 Req'd Qty: 8.00		*	Cust Item II Customer:	D:					
Approvals:	Process Plan	n:	Date://b-9-1.5	Tooling: SPC (Y/N):	Da	te:			Run Star Sto		
Sequence ID/ Work Center II)	Operation Description	· · · · · · · · · · · · · · · · · · ·	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4091	Revi A	sion Nbr		0.00							
Bandsaw Jeaspa Bandsaw		Memo CUT BL	ANK 1.450" LONG	0.00 [4]	10/09/28			20	_ J		· ·
HAAS CNC vertical	machine #1	Memo MACHI FOLIO I DWG R	NE AS PER FOLIO FA920 A REV: AA EV: A	0.00 0.00 A AND DWG	10/09/39 10/09/30	,	٠.	20	<u> </u>		

DEBURR

Dart Ae	rospace	: Ltd								•
W/O:				WORK ORDE	R CHANGES					
DATE	STEP		PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):		PAR #:	Fault Category:	NC	R: Yes	No DQ	A:	Date: _	
	R	esolution:	•	Disposition:	QA	A: N/C C	closed:		Date: _	
NCR:				WORK ORDER NON-CO	ONFORMANC	E (NC	R)			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC	Corrective Action Section B				Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector	
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Work	k Ord	ler ID	61993
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Item	Ш·

D4091-1

Wednesday, September 15, 2010 9:49:08 AM

Revision ID:

Mounting Lug Item Name:

Start Date:

9/14/2010

Start Qty: 8.00

Req'd Qty: 8.00

Required Date: 9/21/2010





Setup Start



Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date:

Tooling:

Date:

Run

Start



Date:

SPC (Y/N):

0.00

0.00

Date:

Tool ID

Stop

Reject

Insp.

Stamp

Sequence ID/ Work Center ID

120

QC

Quality Control

Operation **Description**

QC2- Inspect parts off machine FAI/FAIB

Memo

Set Up/ **Run Hours**

10/09/30

Code Qty

Tool # Plan

Qty 20

Accept

Reject

Number

130

QC

Quality Control

QC8- Inspect parts - second check

and 10/09/30

20 8 _____

Memo

0.00

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

6/6/01

ZO \$ ____

Memo

W/O:			WC	ORK ORDER CHANG	ES				· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes !	No DQA:		Date: _	
	Re	esolution:	Dispositio	n:	_ QA: N/C Clo	sed:		Date:	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR				
DATE	STEP	Description of NC		Corrective Action Section		Verifica		Approval	Approval
	0,2,	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	ı C	Chief Eng	QC Inspector
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								}	

Work Order ID 61993

Wednesday, September 15, 2010 9:49:08 AM



Page 3

Item ID:

D4091-1

Accept

Setup Start

Revision ID:

Item Name:

Mounting Lug

Start Date:

9/14/2010

Start Qty: 8.00

Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____

Date:

Tooling:

Date:

Run

Start

Stop



Required Date: 9/21/2010

Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

150

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M115891 START 10:05

Memo DEN T. 3200

0.00

Set Up/ **Tool ID** Run Hours 0.00 / 10 - 10 - 4

Tool # Plan Accept Qty Code

Reject **Oty**

Reject Number

Insp. Stamp

FINISH. 10:55

160

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

=) Il 10/10/00

70

170

Packaging

Identify as per dwg & Stock Location: 460

Memo

0.00

Packaging

W/O:			WC	ORK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	s No DG	A:	Date: _	
	Re	esolution:						Date: _	
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			tion B		cation	Approval	Approval
DAIL	JOIL!	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat		tion C	Chief Eng	QC Inspector
							- 41		

Work Order ID 61993

Wednesday, September 15, 2010 9:49:08 AM



Page 4

Item ID:

D4091-1

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Required Date: 9/21/2010

Start Date:

9/14/2010

Start Otv: 8.00

Req'd Qty: 8.00

Cust Item ID:

Customer:

Tool ID

Reference:

A	nn	· ro	wa	le•	
A	DH	по	IVA	IS:	

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Stop



QC:

Operation

Date: SPC (Y/N): Date:

Reject Qty

Reject

Insp.

Sequence ID/

Work Center ID

180

Description QC21- Final Inspection - Work Order Release

0.00

Set Up/ **Run Hours**

Tool # Plan Code

Accept Qty

Number

Stamp

Memo

0.00

10/10/05 CZ10/10/05

Quality Control

W/O:			WO	RK ORDER CHANGE	ES				,
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:							
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DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
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Picklist Print

Wednesday, September 15, 2010 9:50:16 AM

Work Order ID: 61993

Parent Item:

D4091-1

Parent Item Name: Mounting Lug



Start Date: 9/14/2010

Required Date: 9/21/2010

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP REV :A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 Lug Extrusion		Manufactured	No			100	f	364.5171	0.1251	1.053474	0/09/2	4	·
				Location		Loc C	<u>Qty</u>	Loc Code			,		
•				MAT06		364.5170	0795						
					43722 45800	194 51	180		7	1525	•		

W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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]				<u></u>		<u> </u>		
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Dispositio	n:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	7)			
DATE	OTED	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	1,1993
Description: Mounting Lug	Part Number:	D4091-1
Description. Mounting Eug	rait Number.	D4031-1
Inspection Dwg: D4091 Rev: a		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.38	+/-0.030	1.379			Vern	5F-12
4.45	+/-0.030	4.452	1		2.1	P
0.27 REF	+/-0.030	,266	_		High , 900	Ge
1.91	+/-0.030	1.911	<u></u>		High gau	
0.69	+/-0.030	690	5		High opu	il
0.293	+/-0.010	,293	/		KEN S	-12
0.735 REF	+/-0.010	,725	/		1,	
0.375	+/-0.010	.375			. 1,	
3.700	+/-0.010	3.700	-		71	
0.625	+/-0.010	.625	/		7	,
0.375	+/-0.010	.375	1		. 31	
Ø0.257	+0.006/-0.001	. 259			4	
R0.40	+/-0.030	.40				
2.310 REF	+/-0.010	2.313			High sous	
			7		1/1/	
						,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,

Measured by:		Audited by:	and,	Preliminary Approval:		
	Date:	10/21/29	Date:	10/09/30	Date:	
Rev	Date	Change			Revisediby	Approved
Α	10.08.05	New Issue			KJ 95	}

W/O:		WORK ORDER CHANGES									
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Dort No		DAD #.	Fault Oats		NOD X						
rait No								DQA: Date:			
Resoluti			Disposition:								
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCF	()					
DATE	STEP	Description of NC	Corrective Action Section B		n B Sign 8		cation	Approval Chief Eng	Approval QC Inspector		
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D4091-1

D4091-1 MOUNTING LUG

SHOP COPY RETURN 60

proposition of 19

SUBJEX 1 1 1 1 1 1 1

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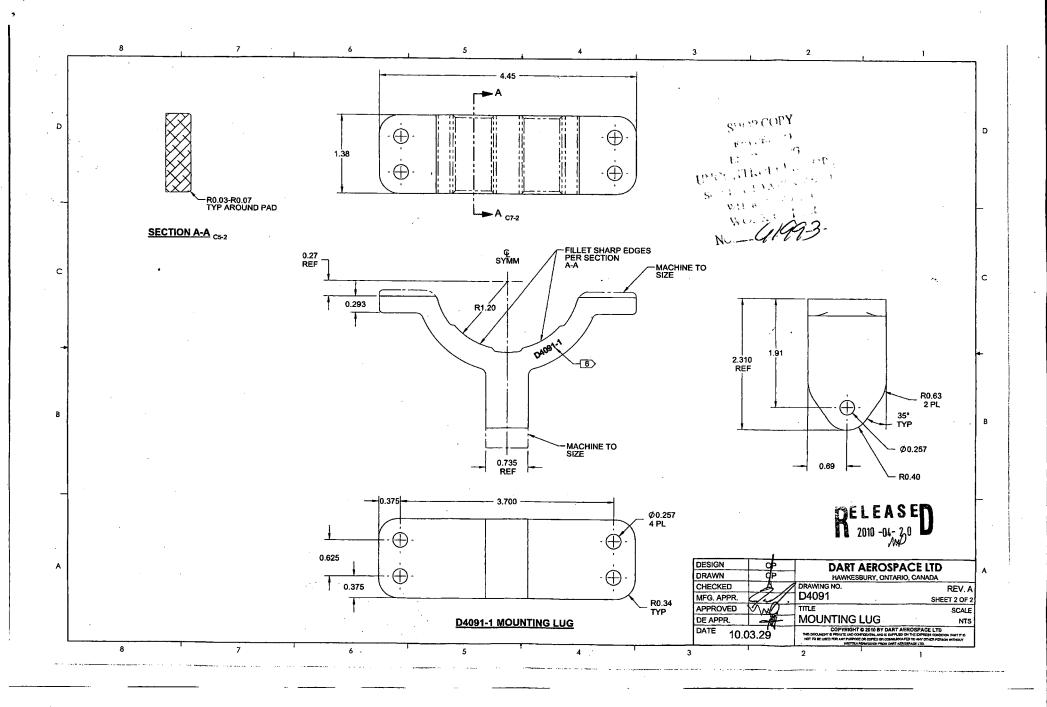
A NEW ISSUE 10.03.29 REV. DESCRIPTION BY DATE DESIGN **DART AEROSPACE LTD** DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4091 MFG. APPR. SHEET 1 OF 2 APPROVED TITLE DE APPR. MOUNTING LUG COPYRIGHT © 2010 BY DART AEROSPACE LTD

THIS DOOLNOTH OF PRIVATE WE COMPRETED WHEN EXPRESS CONSIST
HOT TORK CORP. FOR AMP APPROSC SEE COMPRISE. DATE 10.03.29

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 ± 0.005

8

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROC	CEDURE CHA	URE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No:		PAR #:	Fault Category:NC			NCR: Yes No DQA: Date:						
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NCR:		W	ORK ORD	ER NON-CONFORMA	NCE (NO	CR)						
DATE	STEP	Description of NC	Corrective Action Section B			Verification		Approval	Approval			
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W/O:		WORK ORDER CHAN	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	4:	Date: _			

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DATE	OTED	TEP Description of NC Section A	•	Corrective Action Section B			Verification	Approval	Approval	
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